



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D135-751-011
Job Sheet 200955



Part No: D135-751-011

Job Qty: 1 pcs

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/21/19

Description: SIOP

Type: Stock

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Skidtubes - 1	1 pcs	10/21/19		0.00	0.80	Skidtubes - 1 - B4B		DD
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
140	QC 5	1 pcs	10/21/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
150	Handfinish - 1-1 Chemical-B4B	1 pcs	10/21/19		0.00	0.33	Handfinish - 1 - 1 - B4B		



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CANADA
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Container No: S218406



Part: D135-751-011

Job No: 200955

Serial No/Batch: S218406

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SRD1709SE 18/10/17, T6-LoA RDIMS

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				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	 OCT 04 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	1	10/21/19	0.00 0.00	QC 7 - 10	
	pcs			QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	

					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 70	
					QC 7 - 79	
170 Skidtubes - 2 - B4B	1	10/21/19	0.00 1.00		Skidtubes - 1 - B4B	
pcs					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
180 QC 10	1	10/21/19	0.00 0.00		QC 10 - 10	
pcs					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
185 Handfinish - 6-1- Touch Up- B4B	1	10/21/19	0.00 0.10		Handfinish - 6 - 1 - B4B	
pcs					Handfinish - 6 - 2 - B4B	
					Handfinish - 6 - 3 - B4B	
					Handfinish - 6 - 4 - B4B	
					Handfinish - 6 - 5 - B4B	
					Handfinish - 6 - 6 - B4B	
					Handfinish - 6 - 7 - B4B	
					Handfinish - 6 - 8 - B4B	
					Handfinish - 6 - 9 - B4B	
					Handfinish - 6 - 10 - B4B	
					Handfinish - 6 - 11 - B4B	
					Handfinish - 6 - 12 - B4B	
					Handfinish - 6 - 13 - B4B	
					Handfinish - 6 - 14 - B4B	
					Handfinish - 6 - 15 - B4B	
					Handfinish - 6 - 16 - B4B	
					Handfinish - 6 - 17 - B4B	
					Handfinish - 6 - 18 - B4B	
					Handfinish - 6 - 19 - B4B	
					Handfinish - 6 - 20 -	

				B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
187 QC 7	1 pcs	10/21/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	79
190 Skidtubes - 3 - B4B	1 pcs ✓	10/21/19	0.00 0.77	Skidtubes - 1 - B4B	88
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 5	1 pcs	10/21/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	OCT 29 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	

210 Handfinish - 2-1 Pressure-B4B	1 pcs	10/21/19	0.00 0.08	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 2 - 1 - B4B	
220 Spray Paint - 2 - B4B	1 pcs	10/21/19	0.00 0.25	Handfinish - 2 - 2 - B4B	A OCT 29 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Spray Paint - 1 - B4B	
225 QC 14	1 pcs	10/21/19	0.00 0.00	Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	BK 12-10-30
				Spray Paint - 4 - B4B	
				QC 14 - 15	AL 14-10-30
260 Handfinish - 4-1-Assembly-B4B	1 pcs	10/21/19	0.00 0.74	QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
				Handfinish - 4 - 1 - B4B	AL 14-10-30
270 QC 5	1 pcs	10/21/19	0.00 0.00	Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	

					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS OCT 31 2019 10:40 9-88
					QC 5 - 61	
					QC 5 - 81	
280 Packaging 1-1 - Pick Kit - B4B	1 pcs	10/21/19	0.00	0.00	Packaging 1 - 1 - B4B	✓
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
290 QC 4	1 pcs	10/21/19	0.00	0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
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300 Packaging 3-1 - Stock - B4B	1 pcs	10/21/19	0.00 0.00	QC 4 - 74	
				QC 4 - 75	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
305 DC - 1 - B4B	1 pcs	10/21/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
310 QC 21 - FG	1 pcs	10/21/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

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Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES**** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892. Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

140 - (QC5- Inspect part completeness to step on W/O)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - 1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507, and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time: 5:20:06 end time: 6:12:52 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

180 - (QC10- Inspect visual per QSI004- ground welds)

185 - (Touch up alodine) RE-ALODINE ONLY

187 - (QC7-Inspect Chemical Conversion Coat)

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

200 - (QC5- Inspect part completeness to step on W/O)

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - (Spray Paint / NDT Room) 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer
Batch: _____ 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint

Batch: _____

225 - (QC14- Inspect Spray Paint)

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Screws where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: 52093 CE

270 - (QC5- Inspect part completeness to step on W/O)

280 - (Pick Kit)

290 - (QC4- 100% Inspect kits for completeness)

300 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D135-751-011 PPP

Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

310 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 pcs (1 ea)	120-Skidtubes - 1	5166847
D3504-1	Crossbolt Spacer	2 pcs (2 ea)	170-Skidtubes - 2 - B4B	5146029
D3504-3	Crossbolt Spacer	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5167835
D3504-5	Crossbolt Spacer	2 pcs (2 ea)	170-Skidtubes - 2 - B4B	5222146
D3505-1	Web	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5154725
D3506-1	Doubler	4 pcs (4 ea)	190-Skidtubes - 3 - B4B	5218349
D3506-3	Doubler	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	5154442
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes - 3 - B4B	5222553
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5214460
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-Handfinish - 4-1-Assembly-B4B	5140021
AN3C4A	Bolt	31 Ea (31 ea)	260-Handfinish - 4-1-Assembly-B4B	5217812
AN3C5A	Bolt	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5225291
AN526C1032R10	Screw	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5166181
D2965	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5133570
D2965-3	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5166571
D3492-1	Plug	4 pcs (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5218656
D3492-3	Plug	4 pcs (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5215332
D3492-7	Plug	2 pcs (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5148611
D4918-047	Wearplate Aft	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5218942
D4918-1	Wearplate Fwd	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220102
D4918-3	Wearplate Center Fwd	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220080
D4918-5	Wearplate Center Aft	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220105
NAS1149C0332R	Washer (AN960C10L)	33 Ea (33 ea)	260-Handfinish - 4-1-Assembly-B4B	5218121
NAS1611-007	O-Ring	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	F103697
NAS1611-010	O-Ring	4 Ea (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5217831
NAS1611-013	O-Ring	4 Ea (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5199432
AN3C4A	Bolt	8 Ea (8 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5090636 ✓
D3512-041	Wearplate	2 pcs (2 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5227442 ✓
NAS1149C0332R	Washer (AN960C10L)	8 Ea (8 ea) ✓	280-Packaging 1-1 - Pick Kit - B4B	5218154 ✓

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Skidtubes - 1	D3507-1-BENT	1	10	0
	D3504-1	2	120	0
	D3504-3	1	103	0
	D3504-5	2	6	0
170-Skidtubes - 2 - B4B	D3505-1	1	10	0
	D3506-1	4	13	0
	D3506-3	2	16	0
	MS20601-AD4W3	12	333	0
190-Skidtubes - 3 - B4B	ALS4-1032-225	1	1,872	0
	ALS7-1032-130	38	1,652	0
	AN3C4A	31	584	0
	AN3C5A	2	680	0
	AN526C1032R10	2	53	0
	D2965	1	52	0
	D2965-3	1	45	0
	D3492-1	4	92	0
	D3492-3	4	50	0
	D3492-7	2	14	0
	D4918-047	1	4	0
	D4918-1	1	0	0
	D4918-3	1	4	0
	D4918-5	1	4	0
	NAS1149C0332R	33	2,897	0
	NAS1611-007	2	232	0
	NAS1611-010	4	131	0
	NAS1611-013	4	128	0
260-Handfinish - 4-1-Assembly-B4B	AN3C4A	8	584	0
	D3512-041	2	0	0
	NAS1149C0332R	8	2,897	0
280-Packaging 1-1 - Pick Kit - B4B				

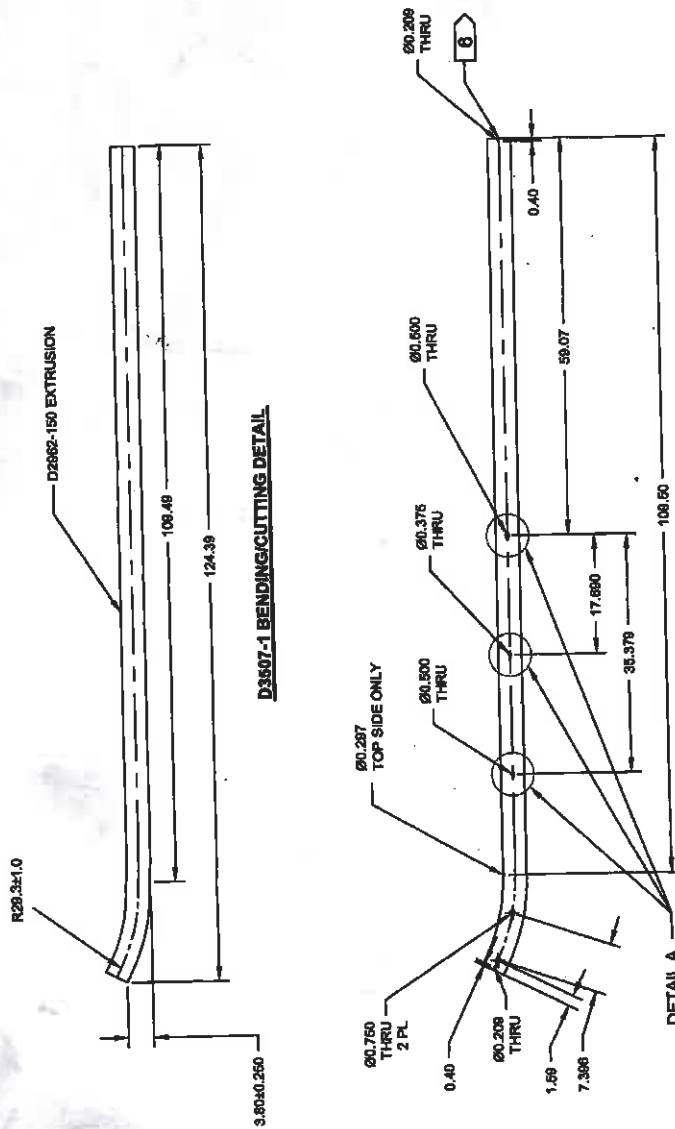
Part Specifications

Specifications could not be found.

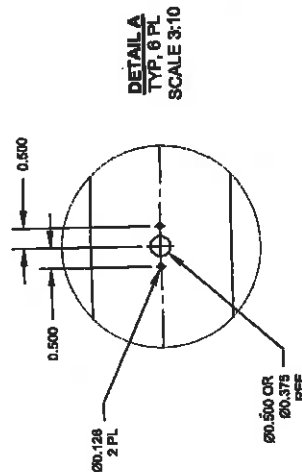
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Qty	Part Number	Description
1	D3507-041	SKIDTUBE ASSEMBLY
1	D2802-160	EXTRUSION
1	D0903	CAP
1	D0903-01	PLUG ASSEMBLY
1	D0903-04	PLUG ASSEMBLY
1	D0903-07	PLUG ASSEMBLY
2	D0904-1	CROSS BOLT SPACER
2	D0904-2	CROSS BOLT SPACER
2	D0904-3	CROSS BOLT SPACER
2	D0904-4	CROSS BOLT SPACER
2	D0904-5	CROSS BOLT SPACER
2	D0904-6	CROSS BOLT SPACER
2	D0904-7	CROSS BOLT SPACER
2	D0904-8	CROSS BOLT SPACER
2	D0904-9	CROSS BOLT SPACER
2	D0904-10	CROSS BOLT SPACER
2	D0904-11	CROSS BOLT SPACER
2	D0904-12	CROSS BOLT SPACER
2	D0904-13	CROSS BOLT SPACER
2	D0904-14	CROSS BOLT SPACER
2	D0904-15	CROSS BOLT SPACER
2	D0904-16	CROSS BOLT SPACER
2	D0904-17	CROSS BOLT SPACER
2	D0904-18	CROSS BOLT SPACER
2	D0904-19	CROSS BOLT SPACER
2	D0904-20	CROSS BOLT SPACER
2	D0904-21	CROSS BOLT SPACER
2	D0904-22	CROSS BOLT SPACER
2	D0904-23	CROSS BOLT SPACER
2	D0904-24	CROSS BOLT SPACER
2	D0904-25	CROSS BOLT SPACER
2	D0904-26	CROSS BOLT SPACER
2	D0904-27	CROSS BOLT SPACER
2	D0904-28	CROSS BOLT SPACER
2	D0904-29	CROSS BOLT SPACER
2	D0904-30	CROSS BOLT SPACER
2	D0904-31	CROSS BOLT SPACER
2	D0904-32	CROSS BOLT SPACER
2	D0904-33	CROSS BOLT SPACER
2	D0904-34	CROSS BOLT SPACER
2	D0904-35	CROSS BOLT SPACER
2	D0904-36	CROSS BOLT SPACER
2	D0904-37	CROSS BOLT SPACER
2	D0904-38	CROSS BOLT SPACER
2	D0904-39	CROSS BOLT SPACER
2	D0904-40	CROSS BOLT SPACER
2	D0904-41	CROSS BOLT SPACER
2	D0904-42	CROSS BOLT SPACER
2	D0904-43	CROSS BOLT SPACER
2	D0904-44	CROSS BOLT SPACER
2	D0904-45	CROSS BOLT SPACER
2	D0904-46	CROSS BOLT SPACER
2	D0904-47	CROSS BOLT SPACER
2	D0904-48	CROSS BOLT SPACER
2	D0904-49	CROSS BOLT SPACER
2	D0904-50	CROSS BOLT SPACER
2	D0904-51	CROSS BOLT SPACER
2	D0904-52	CROSS BOLT SPACER
2	D0904-53	CROSS BOLT SPACER
2	D0904-54	CROSS BOLT SPACER
2	D0904-55	CROSS BOLT SPACER
2	D0904-56	CROSS BOLT SPACER
2	D0904-57	CROSS BOLT SPACER
2	D0904-58	CROSS BOLT SPACER
2	D0904-59	CROSS BOLT SPACER
2	D0904-60	CROSS BOLT SPACER
2	D0904-61	CROSS BOLT SPACER
2	D0904-62	CROSS BOLT SPACER
2	D0904-63	CROSS BOLT SPACER
2	D0904-64	CROSS BOLT SPACER
2	D0904-65	CROSS BOLT SPACER
2	D0904-66	CROSS BOLT SPACER
2	D0904-67	CROSS BOLT SPACER
2	D0904-68	CROSS BOLT SPACER
2	D0904-69	CROSS BOLT SPACER
2	D0904-70	CROSS BOLT SPACER
2	D0904-71	CROSS BOLT SPACER
2	D0904-72	CROSS BOLT SPACER
2	D0904-73	CROSS BOLT SPACER
2	D0904-74	CROSS BOLT SPACER
2	D0904-75	CROSS BOLT SPACER
2	D0904-76	CROSS BOLT SPACER
2	D0904-77	CROSS BOLT SPACER
2	D0904-78	CROSS BOLT SPACER
2	D0904-79	CROSS BOLT SPACER
2	D0904-80	CROSS BOLT SPACER
2	D0904-81	CROSS BOLT SPACER
2	D0904-82	CROSS BOLT SPACER
2	D0904-83	CROSS BOLT SPACER
2	D0904-84	CROSS BOLT SPACER
2	D0904-85	CROSS BOLT SPACER
2	D0904-86	CROSS BOLT SPACER
2	D0904-87	CROSS BOLT SPACER
2	D0904-88	CROSS BOLT SPACER
2	D0904-89	CROSS BOLT SPACER
2	D0904-90	CROSS BOLT SPACER
2	D0904-91	CROSS BOLT SPACER
2	D0904-92	CROSS BOLT SPACER
2	D0904-93	CROSS BOLT SPACER
2	D0904-94	CROSS BOLT SPACER
2	D0904-95	CROSS BOLT SPACER
2	D0904-96	CROSS BOLT SPACER
2	D0904-97	CROSS BOLT SPACER
2	D0904-98	CROSS BOLT SPACER
2	D0904-99	CROSS BOLT SPACER
2	D0904-100	CROSS BOLT SPACER

- GENERAL NOTES:
- 1) MATERIAL: NA
 - 2) FINISH: D3505-1 WEB.
 - 3) STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
 - 4) OPTIONAL: POWDER COAT WHITE (REF. 4.3.1) PER DART QSI 005 4.3.
 - 5) BLACK ANTI-SOUD PAINT (REF. 4.3.1) PER DART QSI 005 4.3.
 - 6) DART QSI 005 4.3.1 INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.3.1.
 - 7) TOLERANCES: UNLESS OTHERWISE NOTED
 - 8) BREAK SHARP EDGES: UNLESS OTHERWISE NOTED
 - 9) IDENTIFICATION: IDENTIFY WITH DART BN PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE.
 - 10) WEIGHT: 24.1 LB (FROM IN-D135-751)
 - 11) WELDING: TO BE DONE PER DART QSI 004
 - 12) INSERT D3506-1 WEB TO LOCATION SHOWN OFF APT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SHAPLEX-244-281 ADHESIVE PER DART QSI 016 AFTER BENDING
 - 13) USE DART DRILL TEMPLATE D10089 TO LOCATE AND DRILL Ø0.287 HOLES (36 PLACES) AFTER FINISHING SEAL WEARPLATE BOLTS WITH SHAPLEX-244-281.
 - 14) DO NOT INSTALL ANSCA BOLTS AND AN880C10L WASHERS IN INDICATED LOCATIONS



D3507-1 DRILLING DETAIL



D	REMOVE D3506-X GASKETS. D4018-X WAS D3506-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN880C1032-10 SCREW	DC	07.08.19
B	ADD GASKET. CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW		
DRAWN	DW		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	13.08.30		
DART AEROSPACE USA, INC			
KENT, WA			
DRAWING NO.			
REV. D			
SHEET 1 OF 2			
TITLE			
EC 135 SKIDTUBE			
DATE			
13.08.30			
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200955 MJS
19-09-19



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____

32.9 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25	8	30	38		*AN3C4A	BOLT
26	8	30	38		*AN960C10L	WASHER
27	2		2		D3512-1	WEARPLATE
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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32-00-00